

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000093**Date Inspected:** 08-Mar-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Liu**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** N/A**Summary of Items Observed:**

The CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present for the welding qualification testing pertinent to the weld procedure qualification record (PQR) HP200713 scheduled for this project. ZPMC welder operator Jiang Xiao Hu was observed by the QA Inspector performing welding operations following the preliminary welding procedure specification PWPS-B-T-2132-1 combined to PQR identified as HP200706. Base metal was designated as A-709-50F-2 (Heat # 06103747020102) and appeared to meet the fracture critical impact test requirement. ZPMC followed the requirements in according with AWS 5.10.3 for fillet welds Tee joints using the semi-automatic flux cored arc welding gas(FCAW-G) process in the horizontal (2F) position with the 1.4 mm diameter TWE-711 electrode. The QA Inspector verified amperages, voltages, travel speeds, preheat and heat interpass temperatures. The QA inspectors recorded at the same test coupon welding parameters the multiple passes (2 total/to determine the minimum multiple fillet weld size)and a single pass(to determine the minimum fillet weld size)at the other side of the test speciment. The QA inspector observed that the welding parameters taken by Quality Control (QC) inspector Cheng Libin and ZPMC QA inspectors Xu Jun and Lu Jinhua appeared to be accurate and in accordance with the contract documents. ZPMC QC Inspector Liu Liu witnessed the testing and performed visual weld inspections. The QA Inspector issued a lot number of B71-003-07 for the multiple pass and B71-007-07 for the single pass after the completion of the PQR. See TL-6032 form for more details.

Summary of Conversations:

The QA inspector did not have any significant conversation on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

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remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Acuna,Alfredo	Quality Assurance Inspector
Reviewed By:	McClary,David	QA Reviewer
